

## Patent Claims

1. An exhaust gas heat exchanger for motor vehicles, comprising a pipe bundle of exhaust pipes (10) which are welded at the ends of the pipe bases (7), and a housing casing (2) which is welded to the pipe bases (7), **characterized** in that the pipe bases (7) are welded to the housing casing (2, 3b) via a circumferential bead (11) which is arranged at the end.  
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2. The exhaust gas heat exchanger as claimed in claim 1, **characterized** in that the pipe bases (7) have a raised rim (7a), and the housing casing has ends (3b) in that the rims (7a) and the ends (3b) are arranged 15 flush and are connected by means of the circumferential bead (11).
3. A method for production of an exhaust gas heat exchanger as claimed in claim 1 or 2, **characterized**  
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  - in that pipes (24), pipe bases (22, 23) and the housing casing (21) are joined to form a heat exchanger block (20', 20"),
  - in that the block (20', 20") is held in a clamping apparatus, and  
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  - in that both the housing casing (21) and the pipe bases (22, 23) as well as the pipes (24) and the pipe bases (22, 23) are welded to one another at the ends in a jig.
- 30 4. The method as claimed in claim 3, **characterized** in that the end welding is carried out by means of at least one laser beam (27, 29).